

Work Order ID 137397

Monday, September 28, 2015 9:42:18 AM

137397

Page 1

Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing
 Start Date: 9/25/2015 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 9/25/2015 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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101		0.00				15	DAS 51 9-89	9/28/15	
101									
Small Fab	Memo	0.00							
Small Fab	Cut 15 sections of 6061t6r0.313w0.065 4.25 long								

110	QC5- Inspect part completeness to step on W/O	0.00				(15)	DAS 38 9-89		
110									
QC	Memo	0.00							
Quality Control	Inspect length of parts 4.25 +/-0.030								

115	Outsource process - Heat Treat	0.00				15	OCT 02 2015	CZ	
115									
Outsource1	Memo	0.00							
Outsource process - Heat Treat	***HEAT TREAT AS PER DWG								

P10.29975

T4

SEP 28 2015

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Hand Finishing

15 ~~0~~ 15-10-19 DGE

Work Order ID 137397***137397***

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Item ID: MISC - Testing

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eng Testing

Start Date: 9/25/2015 Start Qty: 15.00

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Cust Item ID:

Required Date: 9/25/2015 Req'd Qty: 15.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC5- Inspect part completeness to step on W/O	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: 46001 <i>PAULM</i>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
145	QC21- Final Inspection - Work Order Release	0.00							
145									
QC	Memo	0.00							
Quality Control	***STOCK IN ENGINEERING								

For testing
Paul
15-10-19

Steven Drouin

From: Alex Pharand
Sent: Thursday, September 24, 2015 2:08 PM
To: Steven Drouin
Cc: Jean-Luc Menard
Subject: Need samples for testing

Steve,

Can you please cut 15 sections of 0.313 X 0.065 wall tubing 6061-T6 we had tested for the 119 swaging? We are going to send them out to convert to T4. They will need to be ~~3.50~~ 4.25" long min. 1/2 0.30

JL,

Could you bundle these in the heat treat order as well?

Alex

6061 T6 T0.313 W 0.065

B m 132934

Qty

5.3125 Feet

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
305573	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
29975		AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCT	36 - 44 %IACS		87 (60 kHz)	37.75 - 38.75 %IACS
HARDNESS			87 DURETE MESUREE EN HR15TW = 65-67 HR15TW	64.5 - 68 HREW
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
433	16	D4202-1 (401) D4202-1 136610 (17) D5304-1 137050 (15) ENG. TESTING 137397 1 BC = 4 SACS <i>15/10/15 S.P.</i>		

COMMENTAIRES / comments

SOL, ANNEAL 529C, 35 MIN
AGE HARDEN AMBIANT, 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

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DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

certifie que le matériel a été fabriqué, conformément, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

APPROUVÉ par / Approved by:

Isabel Otero
Isabel Otero
QA Technician

DATE: 2015-10-14





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29975**

Purchase Order Date 10/2/2015

PO Print Date 10/2/2015

Page Number 2 of 3

Order From : VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

3	137050	D5304-1 SPACER	10/16/2015 Yes 10/16/2015	17.00	\$0.00	\$0.00
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HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

Line Total: \$0.00

4	137397	ENG. TESTING	10/16/2015 Yes 10/16/2015	15.00	\$0.00	\$0.00
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NOTE: DETAIL C OF C REQUIRED

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Note:

10/2/2015